

Date: Wednesday, 6/7/2006 11:10:37 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOOR ASSEMBLY  
 Job Number : 27445  
 Estimate Number : 12356  
 P.O. Number : *N/A* Part Number : D41269402  
 This Issue : 6/7/2006 S.O. No. : *N/A* Drawing Number : D412-694  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : *N/A* Type : LARGE FAB ASSY Drawing Revision : C1  
 Previous Run : 27340B Material : *N/A*  
 Written By : \_\_\_\_\_ Due Date : 6/16/2006 Qty: 1 Um: Each  
 Checked & Approved By : \_\_\_\_\_  
 Comment : Est Rev: A 05.12.09 New Issue KJ/RF  
 Est. Rev B New dwg rev. ecn781 06.04.18 EC

*See w/024660  
 D412-694-02/04*

## Additional Product

*PO 2008860*

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Issue red decal labels for D412-694-02. CHG005

2.0 COMPOSITE ASSY COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

- D412-694-02 Drill Process
- 1- D412-694-02 Drill Process Drill (7) holes using Ø(#40) drill. Drill (3) holes top/bottom Ø(#40) for insert (do not pass thru) using B30-23000-02 as per Dwg D412-694 page 4 (view P).
- 2- Open (1) hole to 11/16" (0.688) for the handle using unibit. Transfer (4) Ø(#30) holes from D3151-041 to the door and c'sink from far side for the rivet. Transfer (2) holes Ø(3/16") for MS24694-C5 screw as per Dwg D412-694 page 4 (view P). Note: D3151-041 orientation in the door.
- 3- Open (3) holes Ø(#19) or (0.166) top/bottom of the door and c'sink Ø0.300 x 100° from the far side and D3155-041/-042 bracket assembly as per Dwg D412-694 page 4 (view P).
- 4- Drill Ø(#30) holes using drill Jig D3144-T7 for the doublers. Drill (2) holes in two places Ø 3/16" (0.188) for the slot opening. Router slot using D3144-T8/-T9 as per Dwg D412-694 page 2.  
 Note: The (12) holes for the (6) nut plates cannot be less than 0.290" from inside edge.
- 5- Use unibit to open (3) holes to Ø37/64" (0.578) at top/bottom insert for D3163-042 cover assembly as per Dwg D412-694 page 4 (view P).  
 Drill Ø(#30) outer door handle as shown in view Z-Z page 2. Open holes to Ø0.257.
- 6- Drill Pilot holes Ø(#1/8") for rollers using drill Jig DT8703-7. Use unibit to open holes to Ø 37/64" (0.578) for inserts as per Dwg D412-694 page 2, page 6 (view K, L, M, Q).
- 7- Drill Pilot holes Ø(#1/8") for rollers using drill Jig DT8703-8. Use unibit to open holes to Ø 37/64" (0.578)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

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for inserts as per Dwg D412-694 page 2, page 6 (view H, J).

✓ 8- Drill (27) pilot holes Ø(#30) using drill Jig DT8703-9RH for D3126 brackets as per Dwg D412-694 page 2 (view G-G). Use unibit to open holes Ø37/64" (0.578) for inserts.

✓ 9- Drill (2) Pilot holes Ø(#30) by transfer from D3152-042 bracket. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 6 (view Q).

10- Drill (12) Ø(#30) holes from the edge of the door to opposite side for D3162-041 bracket using a long drill and keep drill perpendicular. Ensure (4) holes used from the center of the hole to top and bottom edge of the thick section of D3163-041 cover assembly. Compare hole depth with rivet in the foam as per Dwg D412-694 page 4 (view P) and (view R-R/-S-S). Drill (8) Ø(#30) holes from the edge of the door using a long drill and keep drill perpendicular. About the (4) last holes around the small square of the cover, take the measurement 0.250" from each corner of the D3163-042 cover.

*ml 06/09/15 ✓*

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*06 09 15*

4.0

8000528

Insert



Comment: Qty.: 55.0000 Each(s)/Unit Total: 55.0000 Each(s)

Insert

*119493*

Batch

A/R Hysol EA934NA

*M 100775*

Expiry Date:

*25 April 2007*

✓

5.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1- Install inserts as per Dwg D412-694 page 2 (view G-G); page 6 (view H, J, L, M, Q).  
2- Sand flush excess Hysol around the insert on both doors.

*ml 06/09/20 ✓*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect that inserts are flush with the surface.

*06.09.20 (1)*

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

*ml 06/09/20*

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8.0	QC14	Inspect Spray Paint
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Comment: Inspect Spray Paint

EC 06-09-20

9.0	D31105	Handle
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Handle  
Batch B25502

✓

10.0	D31151	Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Bracket  
Batch B24626

✓

11.0	D31167	Seal ZX2054
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Comment: Qty.: 5.6666 f(s)/Unit Total : 5.6666 f(s)  
Seal ZX2054  
Batch B27239

✓

12.0	D31169	Seal ZX1267
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Comment: Qty.: 6.4166 f(s)/Unit Total : 6.4166 f(s)  
Seal ZX1267  
Batch B17463

✓

13.0	D312041	Bracket Assembly
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)  
Bracket Assembly  
Batch B23700

✓

14.0	D3121044	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Bracket Assembly  
Batch B24678

✓

W/O:		WORK ORDER CHANGES					
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15.0	D31221	Lever
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lever

Batch

25539

✓

16.0	D31231	Cam
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cam

Batch

M 10536-17

✓

17.0	D31241	Hook
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hook

Batch

M 10536-17

✓

18.0	D31242	Hook
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hook

Batch

M 10536-17

✓

19.0	D31261	Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

Batch

25492

✓

20.0	D31263	Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

Batch

18657

✓

21.0	D31265	Bracket
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Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket

Batch

10536-17

✓

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22.0	D31271	Spacer
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Spacer

Batch N/A

✓

23.0	D3132042	Rod Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Rod Weldment

Batch 10536-17

✓

24.0	D3133041	Rod Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Rod Weldment

Batch 10536-17

✓

25.0	D3135041	Handle Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Handle Weldment

Batch B24683

✓

26.0	D3137045	BRACKET ASSEMBLY
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BRACKET ASSEMBLY

Batch B27339

✓

27.0	D31382	Cover
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cover

Batch B23121 B

PTO

✓

28.0	D31391	Guard
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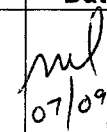
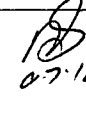

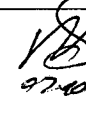
Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)


Guard

Batch B18863

✓

W/O:		WORK ORDER CHANGES					
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07/09/18	27	Lost cover Re-put in inventory?? when moving parts??		Re-pick one D3138-2 in stock <del>02101245</del> M 24341	 07/09/18	 07-10-18	 07-10-18	 07-10-18

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:  Date: 07/10/18

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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29.0	D31394	Guard
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Guard  
Batch B24700

30.0	D314006	Door Kit
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Door Kit  
Batch B27445

31.0	D31411	Spring #204-032-734-001
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Spring #204-032-734-001  
Batch B27236-1

32.0	D314413	Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Doubler  
Batch 21911

33.0	D3144111	Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Doubler  
Batch B27380

34.0	D3144115	Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Doubler  
Batch B22021

35.0	D3144123	Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Doubler  
Batch B22025

W/O:		WORK ORDER CHANGES					
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			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

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Part Number: D41269402

Job Number:



Seq. #:	Machine Or Operation:	Description :
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36.0	D31481	Clevis
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clevis

Batch 1710536-17

✓

37.0	D3151041	Doubler Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler Assembly

Batch B24685

✓

38.0	D3152042	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch B18867

✓

39.0	D3155041	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch B27178

PTO

✓

40.0	D3155042	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch B24343

✓

41.0	D31561	Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bracket

Batch B24706

✓

42.0	D3162041	Bracket Assembly
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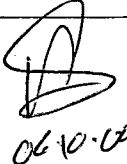

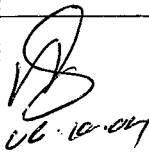
Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bracket Assembly ① B24709

Batch ⑨ B24688

✓

W/O:		WORK ORDER CHANGES					
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06/09/25	39	make a deep groove on D3155-041 with Cam <del>D3123</del> D3123-1 when try to fix		Scrap one D3155-041 <del>to be</del> replace by new one in stock.	 06/09/25	 06.10.24	 05.10	 06.10.24

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DD Date: 07/10/24

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43.0	D3162043	BRACKET ASSEMBLY
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

B 27348

✓

44.0	D3162044	BRACKET ASSEMBLY
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

B 24977

✓

45.0	D3163042	Cover Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cover Assembly

Batch

27484

✓

46.0	D3183042	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

B 27604

✓

47.0	D32031	Handle
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle

Batch

B 24956 A

✓

48.0	D33081	Doubler
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Doubler

Batch

B 21912

✓

49.0	AN52510R6	Screw
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Screw

Batch

M 15943

✓

W/O:		WORK ORDER CHANGES					
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50.0	AN52510R7	Screw
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

Batch

15387(2)

101203(6)

✓

51.0	AN960JD8	Washer
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch

M11989

✓

52.0	AN960JD10L	Washer
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Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch

M16612

✓

53.0	AN960JD10LL	Washer
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Comment: Qty.: 15.0000 Each(s)/Unit Total : 15.0000 Each(s)

Washer

Batch

11763

✓

54.0	AN960JD416L	Washer
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch

3154

✓

55.0	BSP45	Commercial Rivet
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Comment: Qty.: 79.0000 Each(s)/Unit Total : 79.0000 Each(s)

Commercial Rivet

Batch

M11821

✓

56.0	BSP46	Commercial rivet
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Commercial rivet

Batch

M19098

✓

W/O:		WORK ORDER CHANGES					
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57.0	M7885243	Rivet
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rivet

Batch

m19099

✓

58.0	MS203922C9	Pin
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

m11784

✓

59.0	MS203922C17	Pin
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

m11735

✓

60.0	MS203923C21	Pin
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

m11765

✓

61.0	MS20426AD33	Rivet
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Rivet

Batch

~~M520126~~ m1563

✓

62.0	MS20426AD45	Rivet
------	-------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) For this step I need 46 Rivet

Rivet

Batch

~~M3456~~ m2546  
Do not change w/o

✓

63.0	MS20426AD47	Rivet
------	-------------	-------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)


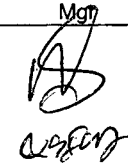
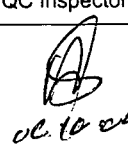
Rivet

Batch

m12655

PTO

✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06/09/19	63	Permanent change (See $\Delta$ CI on View R-R) Now using only 4 rivets MS20426 AD4-7 AND 12 rivets M7825-3-4-4 MIS659		06.09.19			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 6/7/2006 11:10:38 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27445

Part Number: D41269402

Job Number:



Seq. #:	Machine Or Operation:	Description :
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64.0	MS21042L4	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch

11991

✓

65.0	MS21042L08	Nut
------	------------	-----



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch

15003

✓

66.0	MS21072L3	Nutplate
------	-----------	----------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nutplate

Batch

18728

✓

67.0	MS24665151	Cotter Pin
------	------------	------------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Cotter Pin

Batch

M17566

✓

68.0	MS24693S271	Screw
------	-------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

M14478

✓

69.0	MS24694C5	Screw
------	-----------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

M11755

✓

70.0	MS24694S5	Screw
------	-----------	-------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Screw

Batch

M11735(5)

M18949(1)

✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 6/7/2006 11:10:38 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27445

Part Number: D41269402

Job Number:



Seq. #:	Machine Or Operation:	Description :
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71.0	MS24694S50	Screw
------	------------	-------



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Screw

Batch

M14206

✓

72.0	MS24694S98	Screw
------	------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

M16255

✓

73.0	MS27039105	Screw
------	------------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Batch

M3501

✓

74.0	MS27039106	Screw
------	------------	-------



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Screw

Batch

M11754

P.T.O

✓

75.0	MS27039108	Screw
------	------------	-------



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Screw

Batch

13356

P.T.O

✓

76.0	MS35275233	Screw
------	------------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Batch

M11822

✓

77.0	MS35649264	Nut
------	------------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)


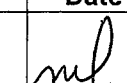

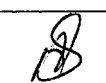

Nut


Batch

M11822

✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
07/09/18	74 and 75	Lost these screws. Re-put in inventory 777 when moving parts...	 QSM	Re-Pack these parts 13x MS 27039-108 M104215 14x MS 27039-106 M11754	 07/09/18	 07.10.16	 QSM	 07.10.16

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 02/10/24

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



Date: Wednesday, 6/7/2006 11:10:38 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27445

Part Number: D41269402

Job Number:



Seq. #:	Machine Or Operation:	Description :
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78.0	MS356503252	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch

M11735

✓

79.0	MS518597	Washer
------	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch

11822

✓

80.0	NAS43DD310	Spacer
------	------------	--------



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Spacer

Batch

M19185

PTO

✓

81.0	NAS43DD314	Spacer
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Spacer

Batch

11785

PTO

✓

82.0	COMPOSITE ASSY	COMPOSITE ASSEMBLY
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Comment: COMPOSITE ASSEMBLY

D412-694-02 Assembly Process

- ✓ 1- Install D3162-041 as per Dwg D412-694 page 4 (view R-R/S-S) and D3156-1 bracket as per (view T-T/U-U). Open holes to #30 (0.128) for rivet and alodine the open holes.  
Note: Start installation window side. Wait to fix D3162-043/-044.
- ✓ 2- Install D3151-041 Doubler as per Dwg D412-694 page 4 (view P).
- ✓ 3- Connect D3132-042 Rod Weldment with D3122-1 Lever and D3133-042 Rod Weldment as per Dwg D412-694 page 4 (view P).
- ✓ 4- Assemble D3123-1 Cam with D3124-1/-2 Hook with D3155-041/-042 Bracket Assembly as per Dwg D412-694 page 4 (view P).
- ✓ 5- Install D3203-1 handle with D3308-1 doubler as per Dwg D412-694 page 2 (view Z-Z).
- ✓ 6- Install D3155-041/-042 Bracket Assembly and D3110-5 Handle as per Dwg D412-694 page 4 (view P) and

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
07/09/18	80 and 81	Lost these spacers Re-put in inventory when moving parts ???	IB wsm	Re-pick these parts 7X NAS 43 DD30 M19347 6X NAS 43 DD314 M19347	ml 07/09/18	IB 07-10-16	IB 07-10-16	IB 07-10-16

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 07/10/24

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27445

Part Number: D41269402

Job Number:



Seq. #:

Machine Or Operation:

Description :

page 2. Adjust rod weldment until everything works properly and looks in place.

83.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Doc 10-04*

84.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

✓ D412-694-02 Assembly Process (Continued)

✓ 1- Install D3116-7-0680 Seal and doublers. Transfer slot opening in the seal as per Dwg D412-694 page 2 (view V-V and N).

Note: If this is the D412-694-013, wait until the VIP trim is fixed on the door.

✓ 2- Install D3110-5 Handle Assembly in the D3163-042 Cover Assembly. Ensure Handle works freely. Ensure D3163-042 cover assembly is aligned with the door edge on both sides and D3110-5 Handle works properly.

✓ 3- Transfer the holes to the cover with the hole finder. EXCEPTION: the (4) holes around the handle. Install the bracket with the holes from the small square of the cover (Ø0.250")

✓ 4- Open 15/64" (0.234) holes to D3163-042 cover assembly and D3135-041 handle weldment. Transfer D3139-1/-4 guard holes in cover assembly and drill holes for nutplate. Deburr and touch up holes with alodine as per Dwg D412-694 page 2.

✓ 5- Install MS21072-L3 Nutplate and Guard as per Dwg D412-694 page 2.

✓ 6- Transfer (#30) holes from D3144-13 doubler to seal and door. Ensure D3116-9-0770 is properly aligned as per Dwg D412-694 page 2 (section NN-NN). Apply 732 RTV Clear (A/R) in the hole prior to installing rivet and then in the rivet head after installation.

*M16368  
17 Feb 2007 exp.*

7- Install D3126 Brackets and D3138-2 Cover as per Dwg D412-694 page 2 (view G-G and NN-NN).

✓ 8- Install and assemble brackets as per Dwg D412-694 page 2 and 5 (view H, J, L, M and Q).

*m/06/10/05*

85.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*PTO  
See Sheet attached*

86.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY




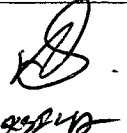





Comment: COMPOSITE ASSEMBLY

1- Finish installing D3163-042 in the door.

2- Install red decal before closing cover.

*m/07/10/16 X1*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
07/10/10	85	Corner Upper Left is to curved. Have to take out  2".300 ← 5".850 ↓ end .300 deep on corner	 	See attached sheet	 07/10/10	 07.10.10	 07.10.10	 07.10.10

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/10/04

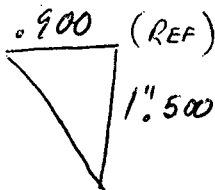
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

W/O 27445

Step 85. on door D 412-694-02

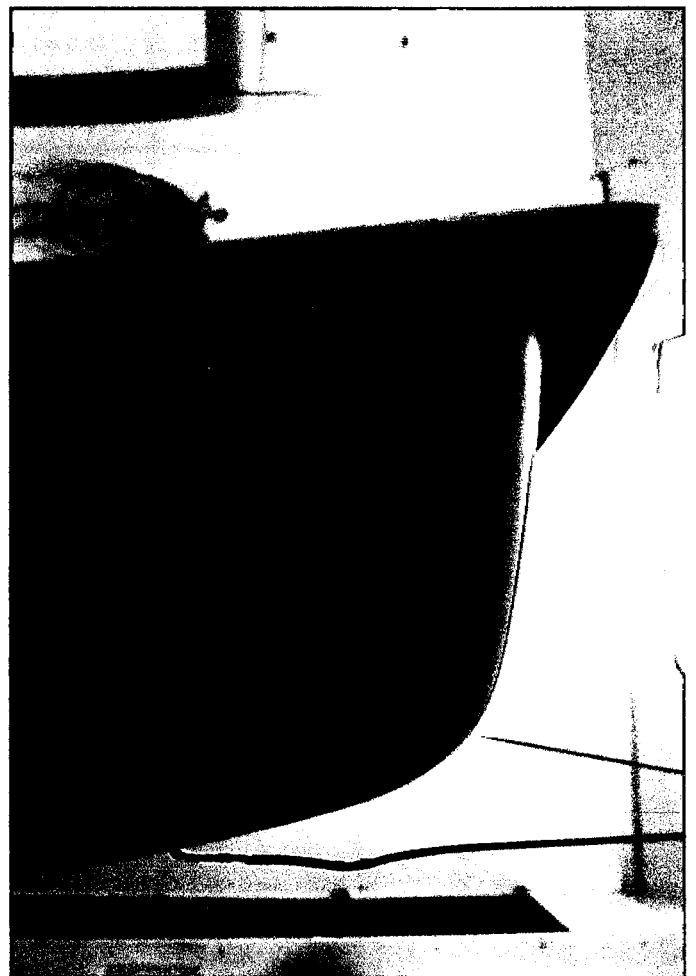
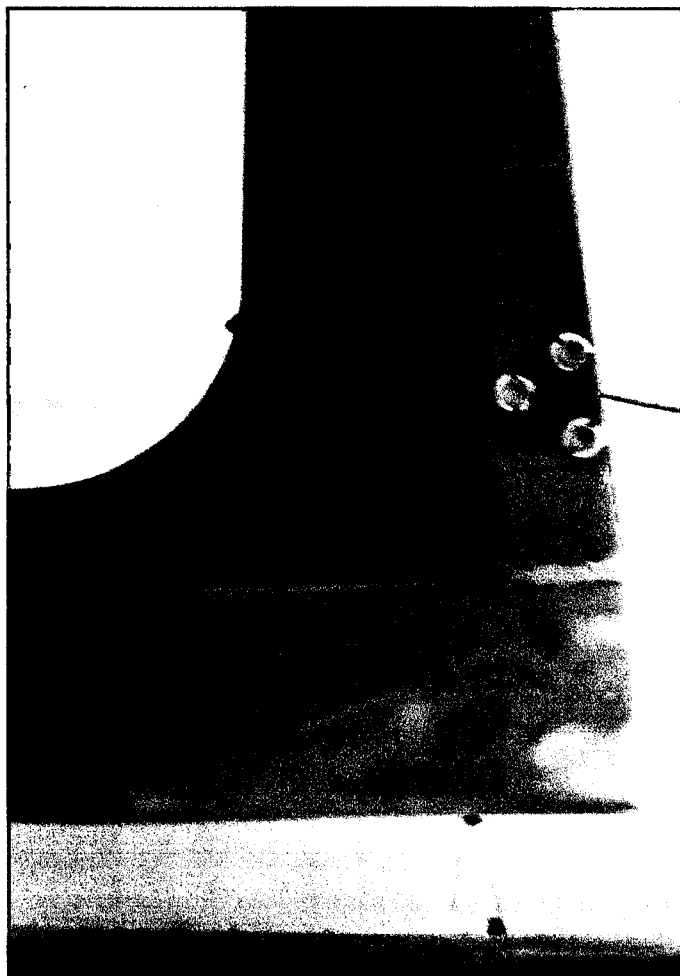
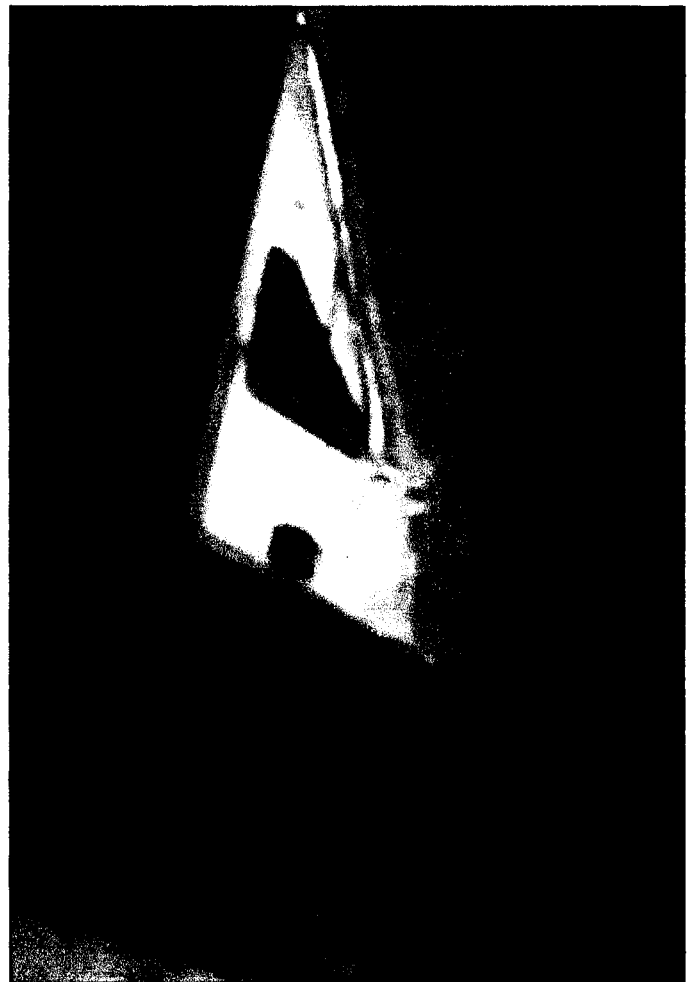
- Buffed the aft Upper Corner
- Have to cut the doubler D3140-241 for having the good shape.
- The joint was cover by new small hand made doubler about



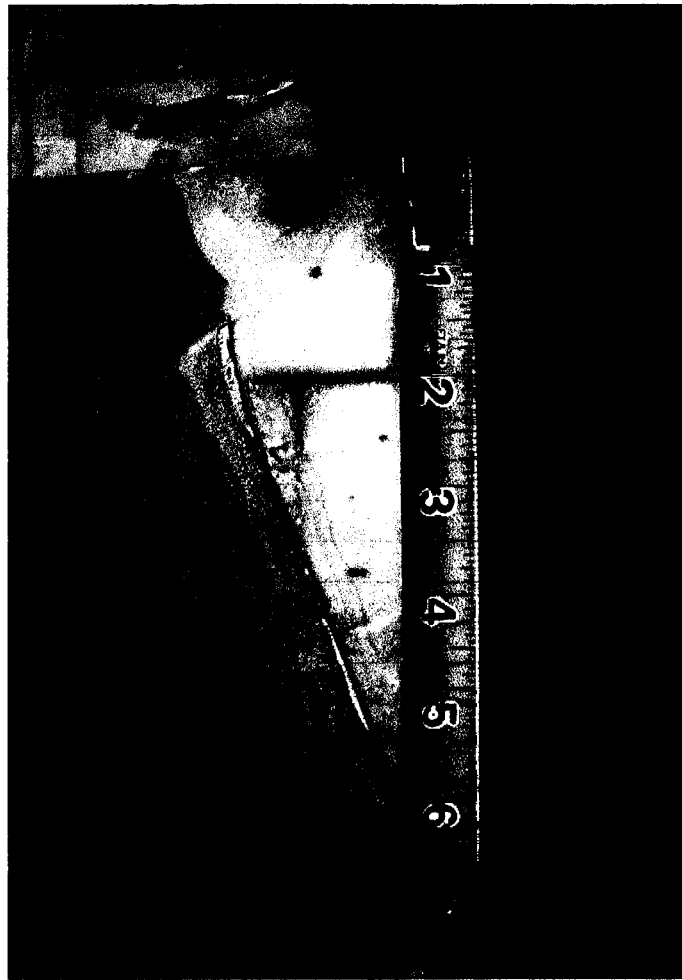
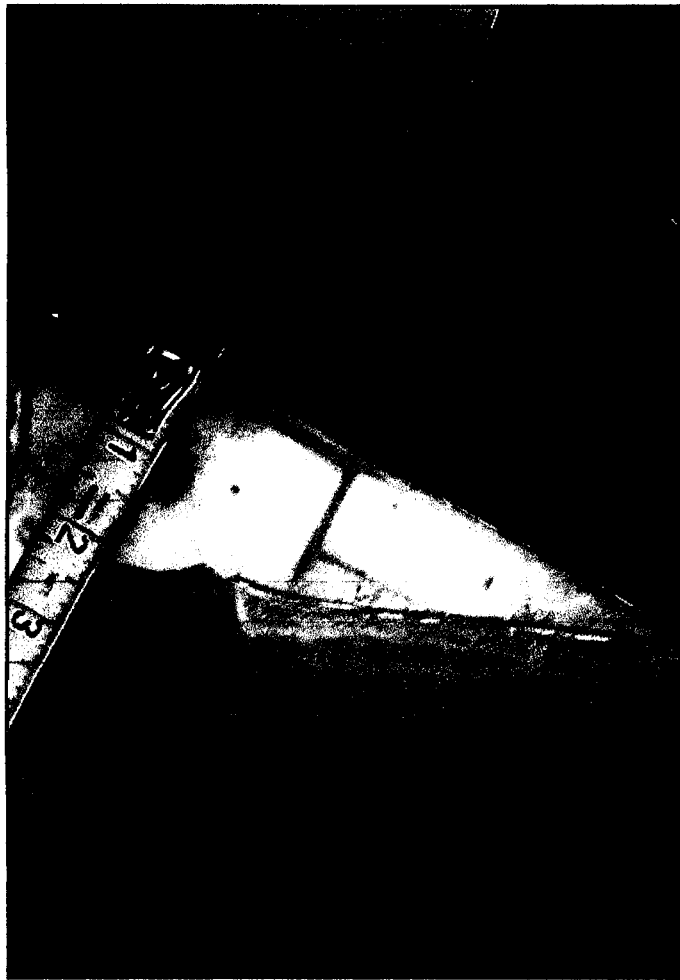
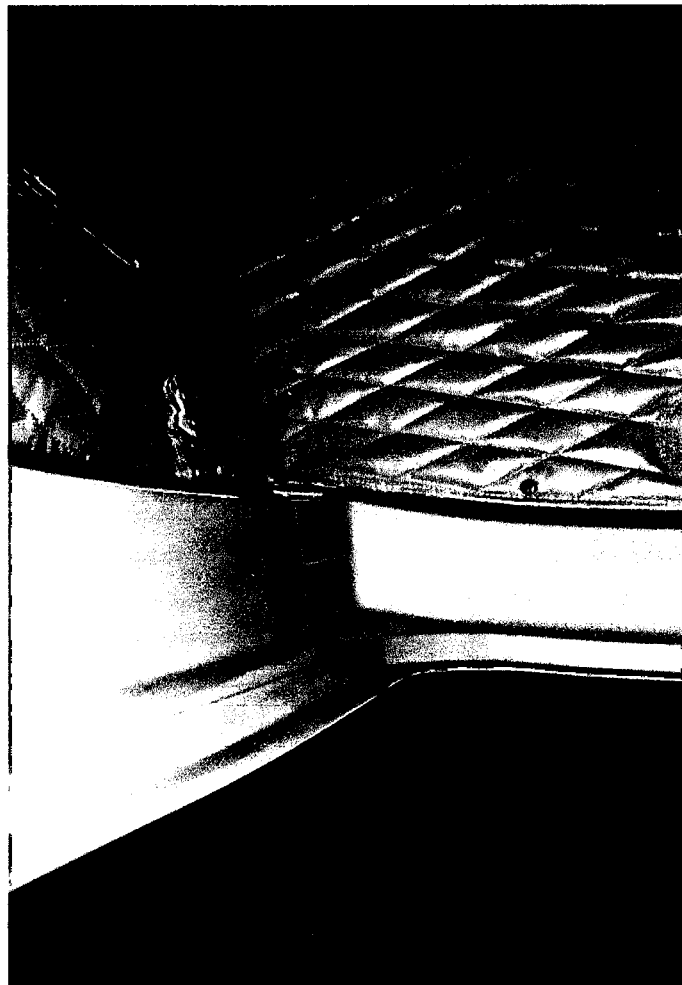
for hiding the joint of foam and reinforce

- Use 2024-T3 .020 as doubler D3140-241 B# M11622
- Rough Scrog - Alodine - Press foam of the door for fit the New piece
- Hypsol EA 9309 M103866 A/R - Exp. March 19/2008
- milled fiber M100859 A/R
- 9oz E-glass (2 layers) M104548 A/R
- let dry 24 hours and RE prime where Need it. after sanding.

M107/10/12



10151







Date: Wednesday, 6/7/2006 11:10:38 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27445

Part Number: D41269402

Job Number:



Seq. #:

Machine Or Operation:

Description :

87.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Install door on mock up helicopter to insure proper fit and function.

*18 07-10-16*

88.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*CL 07/10/17 ①*

89.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*① 07/10/17*

Job Completion



*U 07-10-16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_